

Work Order ID 82033

82033

Page 1

March-22-12 10:29:44 AM

Item ID: D2806-1

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Bushing

Start Date: 22/03/2012 Start Qty: 24.00

24

Cust Item ID:

Required Date: 05/04/2012 Req'd Qty: 24.00

24

Customer:

Reference:

Approvals:

Process Plan: MLJ

Date: 12/03/22

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2806

Rev A

100

0.00

100

DOOSAN LATHE

Doosan

Memo

0.00

Doosan Lathe

1- Turn as per Folio FA105 Rev: 14 & Dwg D2806 Rev: 4 2-Deburr
per dwg D2806

12/4/1

28

110

0.00

110

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

12/4/1

28

120

0.00

120

QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

OK 12/04/02

28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130 Chemical Conversion Coat per QSI005 4.1 0.00

130

HandFinish

Memo

0.00

Hand Finishing

24 124.2

140 QC3- Inspect Part Finish 0.00

140

QC

Memo

0.00

Quality Control

24 X P/M 12/04/02

150 Identify as per dwg & Stock Location: 018 0.00

150

Packaging

Memo

0.00

Packaging

JB (24) 12/04/03

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Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.00

Quality Control

12-04-3

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

March-22-12 10:29:48 AM

Page 1

Work Order ID: 82033

82033

Parent Item: D2806-1

D2806-1

Parent Item Name: Bushing

Start Date: 22/03/2012

Required Date: 05/04/2012

Start Qty: 24.00

Required Qty: 24.00

Comments: IPP: B05.03.11Part now turned KJ/JLM
IPP Rev:C Now on Doosan Lathe JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M6061T6H1.000

Purchased

No

100

f

6.9880

0.0916

2.314105

M6061T6H1 000

**

6061-T6 HexBar 1.00

Location

Loc Qty

Loc Code

MAT012

6.988

109478

0.421

116623

0.897

119275

5.67

857
1.418

12/8/11

W/O:		WORK ORDER CHANGES					
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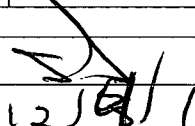

NOTE: Date & initial all entries



DART AEROSPACE LTD		Work Order:	82033
Description: Bushing		Part Number:	D2806-1
Inspection Dwg: D2806 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.000	+/-0.010	1.004	/		SA-5	OK
1.155	+/-0.010	1.150	/			
0.250	+/-0.010	.242	/			
0.063 x 45°	+/-0.010	0.063 x 45°	/			
0.080 x 45°	+/-0.010	0.080 x 45°	/			
0.495	+0.000/-0.005	.493	/			
0.750	+0.000/-0.005	.747	/			
Ø0.257	+0.005/-0.000	Ø.260	/			
0.094	+/-0.010	.093	/			

Measured by: 	Audited by: 	Prototype Approval:	N/A
Date: 12/04/02	Date: 12/04/02	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.02.25	New Issue	KJ/RF	
B	08.01.16	0.094 dimension added	KJ/EC/DD 	

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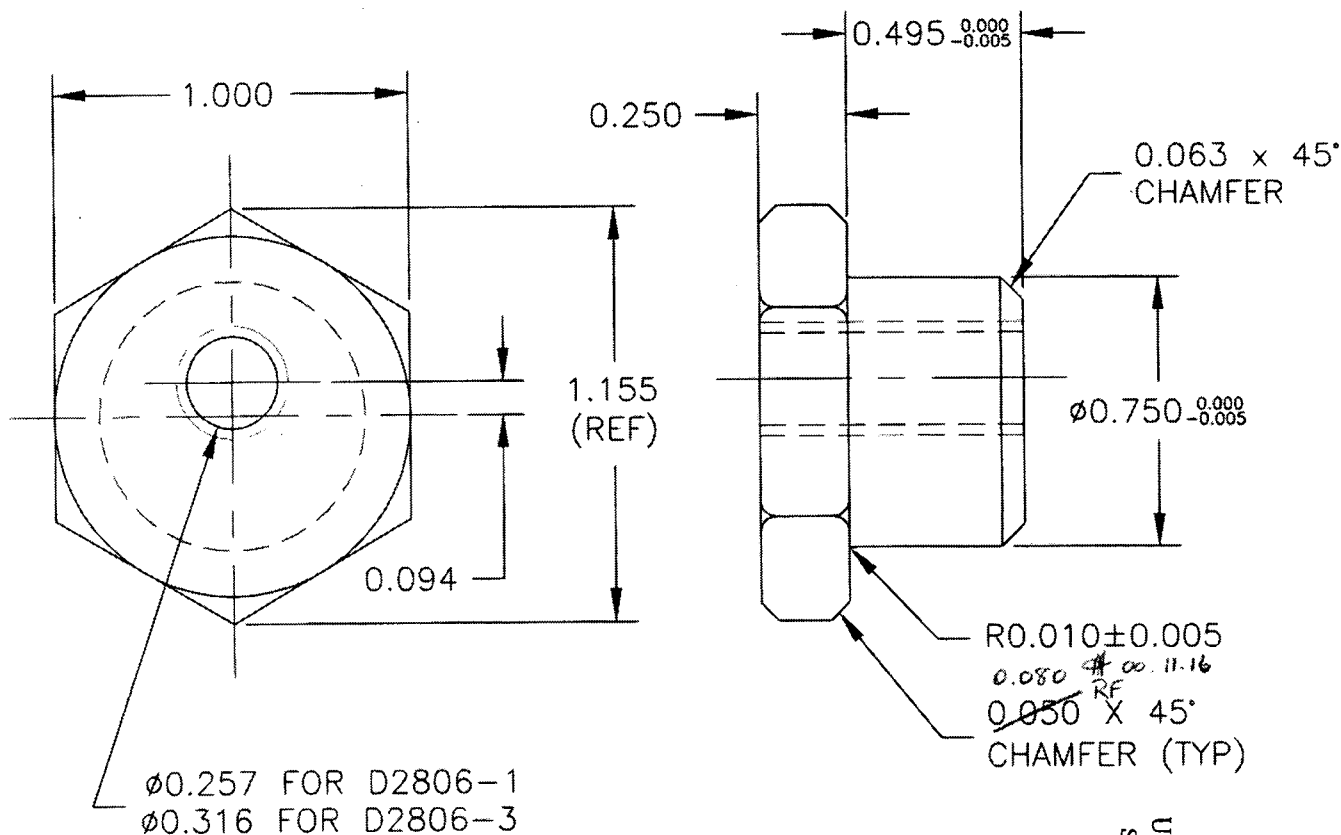
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DESIGN #	DRAWN BY #	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED CP	APPROVED #	DRAWING NO. D2806	REV. A SHEET 1 OF 1
DATE 00.11.08		TITLE BUSHING	SCALE 2:1
A	00.11.08	NEW ISSUE	

RELEASED
00.11.13 #



D2806-1 (DRILL $\phi 0.257$ HOLE)
D2806-3 (DRILL $\phi 0.316$ HOLE)

MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) OR (QQ-A-225/8)
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
BREAK ALL UNMARKED SHARP EDGES 0.010 TO 0.020
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 82033 MJS
12/03/12

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